

WORK ORDER 2007-14

Date opened: 15 May, 2007

Project: External Attachment Provisions
Type: Bell 407

Batch Quantity: 34 x 60620-01 Aft Block w/ Barrel Nuts

Approval: SH00-48
Drawing List: DCL493, DCL700

<u>Fabrication and Assembly Drawing(s)</u>	<u>Description</u>
60620, Rev. 0	Aft Landing Gear Block
60622, Rev. 0	Barrel Nut
60624, Rev. 0	Barrel Nut

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: _____

Inspector Signature: *Jeff Clarke* Date: Dec 14/07

Drawing: 60620 Revision 0
Assembly: 60620-01 Aft Block

Qty	Part #	Description	Material	P.O./W.O.	Checked
34	60620-01	Aft Block	6061-T6 Aluminum, 1" x 3" Bar	7028	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 60620			<i>Jeff Clarke</i>

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 60622 Revision 0
Assembly: 60622-01 Barrel Nut

Qty	Part #	Description	Material	P.O./W.O.	Checked
34	60622-01	Barrel Nut	304 Stainless 3/4" Rod	4072	


Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 60622			J.C.

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 60624 Revision 0
Assembly: 60624-01 Barrel Nut

Qty	Part #	Description	Material	P.O./W.O.	Checked
34	60624-01	Barrel Nut	304 Stainless, 11/16" Rod	6060	
34	3591-6CN	Locking Helicoil	Helicoil	--	

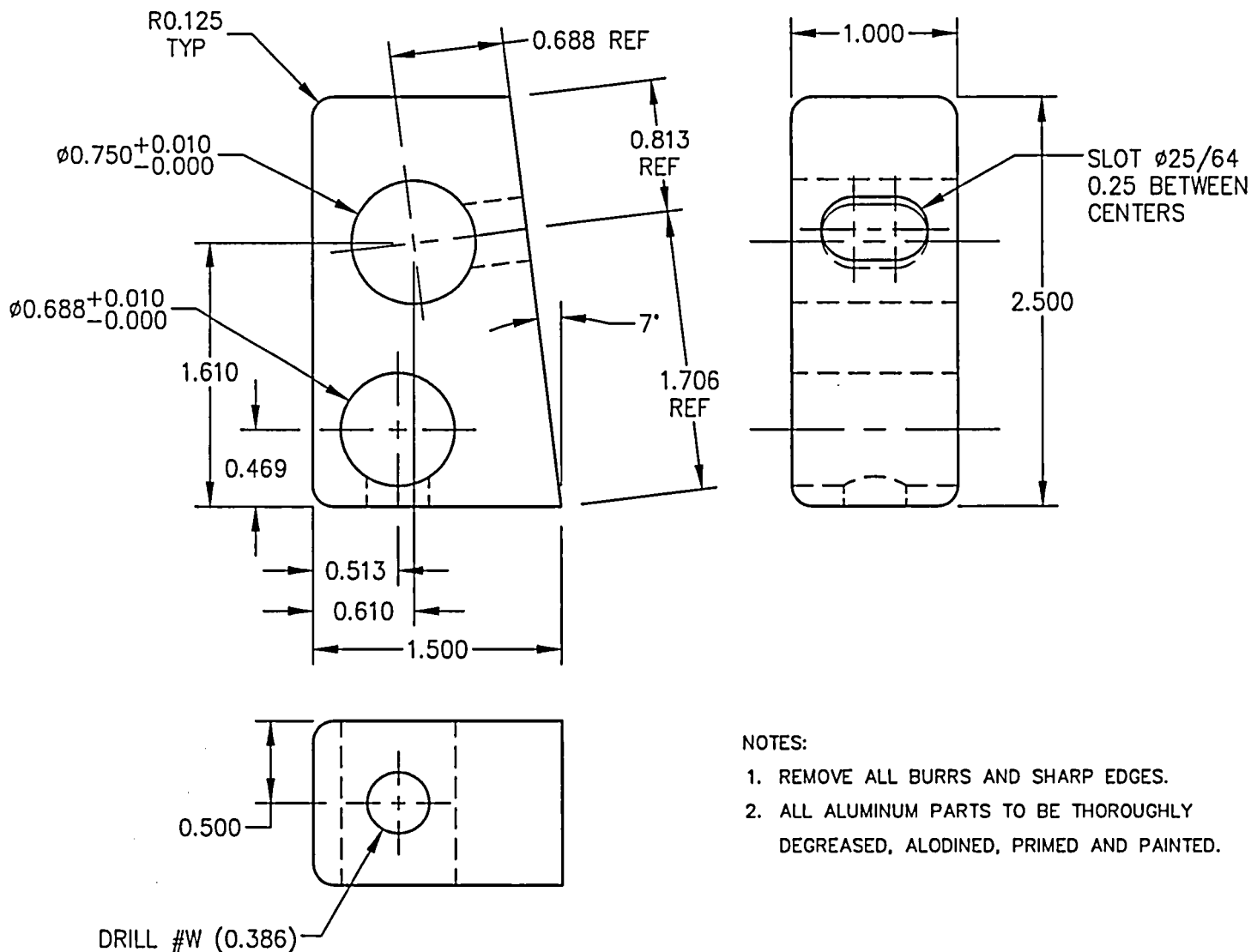
Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 60624			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	BJC	24 MAR 04
1	ANGLE OF FRONT FACE CHANGED TO 7°	BJC	11 APR 07



NOTES:

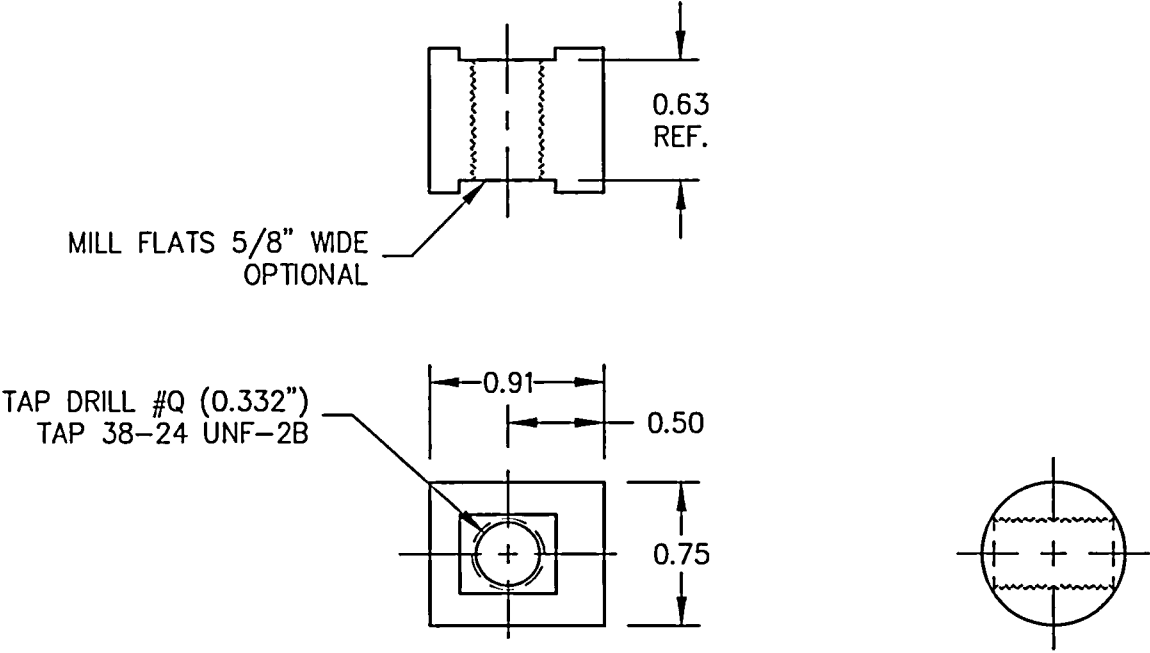
1. REMOVE ALL BURRS AND SHARP EDGES.
2. ALL ALUMINUM PARTS TO BE THOROUGHLY DEGREASED, ALODINED, PRIMED AND PAINTED.

(01) BLOCK

2	60620-01	01	BLOCK	6061-T6 ALUMINUM	QQ-A-200/8	1.0 X 2.5 RECT. BAR
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

	APPROVALS		DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net				
	DRAWN: JEFF CLARKE		24 MAR 2004					
	CHECKED: E. BURGOIN		24 MAR 2004					
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1			BELL 407 EXTERNAL ATTACHMENT PROVISIONS BLOCK FABRICATION				
				SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1		A4	60620	1	

LIST OF MATERIALS					
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
60622-01	01	BARREL NUT	AISI 304 SS	MIL-S-5059	ø3/4" BAR



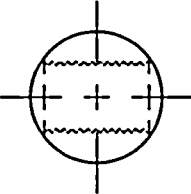
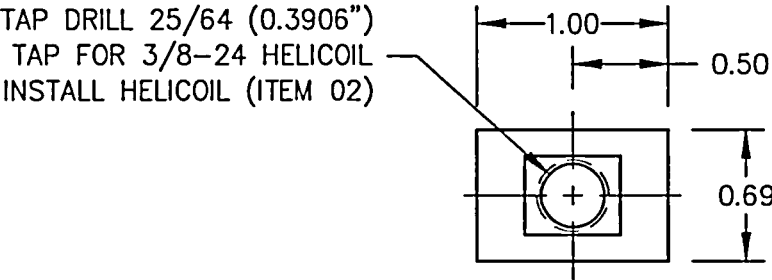
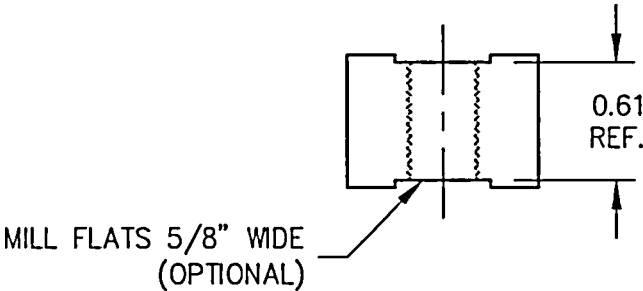
01 BARREL NUT

NOTES:
1. REMOVE ALL BURRS AND SHARP EDGES.

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DRAWN: JEFF CLARKE		29 MAR 2004					
CHECKED: E. BURGOIN							
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SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
SHEET 1 OF 1		A1		60622		0	

0	CREATED FROM 49320, REV. 1	BJC	MAR 29/04
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
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LIST OF MATERIALS					
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
60624-01	01	BARREL NUT	AISI 304 SS	MIL-S-5059	ø11/16" BAR
3591-6CN	02	SELF-LOCKING THREAD INSERT	HELICOIL		3/8-24 UNF x 9/16" LONG



01 BARREL NUT

NOTES:
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0	CREATED FROM 49320, REV. 1	BJC	MAR 29/04
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE

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CHECKED: E. BURGOIN					
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DECIMALS	ANGLES	SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
X.XXX ±0.010	±1/2°		A1	60624	0
X.XX ±0.03		SHEET 1 OF 1			
X.X ±0.1					

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AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: BLOCK Part #: 60620-01

Approval #: SH00-48 Serial #: _____

WO #: 2007-14 Quantity: 2

Eligibility: BELL 407 Work Status: Manufactured

Remarks: _____

I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.

Dec 14/07
Date

Jff Clark
Inspector's Signature

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<p><i>I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.</i></p>		
<div style="display: flex; justify-content: space-between;"> <div style="width: 30%;"> <u>Dec 14/07</u> Date </div> <div style="width: 60%;"> <u>[Signature]</u> Inspector's Signature </div> </div>		

AERO Design Ltd. 2013 - 39 th Ave. NE Calgary, AB, T2E 6R7	AUTHORIZED RELEASE CERTIFICATE	TRANSPORT CANADA TCCA 24-0078 AMF # 73-04
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V1H

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ELBOW RIVER
HELI

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<u>Dec 14/07</u>		<u>[Signature]</u>			
Date		Inspector's Signature			

AERO Design Ltd. 2013 - 39 th Ave. NE Calgary, AB, T2E 6R7		AUTHORIZED RELEASE CERTIFICATE		TRANSPORT CANADA TCCA 24-0078 AMF # 73-04	
Product: <u>BARREL NUT</u>		Part #: <u>60622-01</u>			
Approval #: <u>SH00-48</u>		Serial #: _____			
WO #: <u>2007-14</u>		Quantity: <u>2</u>			
Eligibility: <u>BELL 407</u>		Work Status: <u>Manufactured</u>			
Remarks: _____					
<i>I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.</i>					
<u>Dec 14/07</u>		<u>[Signature]</u>			
Date		Inspector's Signature			

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Product: <u>BARREL NUT</u>		Part #: <u>60624-01</u>			
Approval #: <u>SH00-48</u>		Serial #: _____			
WO #: <u>2007-14</u>		Quantity: <u>2</u>			
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AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA
TCCA 24-0078
AMF # 73-04

Product: BLOCK Part #: 60620-01
Approval #: SH00-48 Serial #: _____
WO #: 2007-14 Quantity: 2
Eligibility: BELL 407 Work Status: Manufactured
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Date

Jeff Clark
Inspector's Signature

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2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

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Jeff Clark
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UNIVERSAL
HELICOPTERS

AERO Design Ltd.
2013 - 39th Ave. NE
Calgary, AB, T2E 6R7

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Dec 14/07
Date

JH Chik
Inspector's Signature

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Date


JH Chik
Inspector's Signature

NOTIFIED

AIR
SUPPORT

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<div style="display: flex; justify-content: space-between;"> <div style="width: 30%;"> <u>Dec 14/07</u> <small>Date</small> </div> <div style="width: 60%; text-align: center;">  <small>Inspector's Signature</small> </div> </div>		

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VALLEY
HELICOPTERS

AERO Design Ltd. 2013 - 39 th Ave. NE Calgary, AB, T2E 6R7	AUTHORIZED RELEASE CERTIFICATE	TRANSPORT CANADA TCCA 24-0078 AMF # 73-04
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Calgary, AB, T2E 6R7

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Oct 25/07
Date

Jeff Clark
Inspector's Signature

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Calgary, AB, T2E 6R7

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Aug 7/07
Date

Jeff Clarke
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Aug 7/06
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JH Chuk
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